

(2)

Work Order ID 76495***76495***

Page 1

Tuesday, November 15, 2011 3:59:34 PM

Item ID: D3324-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Basket Base Assembly

Start Date: 11/15/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

*L*Date: 11-15 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3324	Rev B

100

100

Large Fab

0.00

*LPC 11-11-23**SJ 11-11-23*

Large Fab

Memo

0.00

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	<u>119441</u>
4	D3324-3	Full Length Tube	<u>119441</u>
2	D3324-5	Top End Tube	<u>119441</u>
2	D3324-7	Bottom EndTube	<u>119441</u>
10	D3324-9	Vertical Tube	<u>119441</u>

1X

Large Fab

2- Weld as per dwg

A/R 4130 rod batch: 118875

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

Memo

0.00

Quality Control

1 0 8 11-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A.	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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1

Cust Item ID:

Required Date: 11/25/2011 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/11/24

0.00

121

121

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

8/11/24

W/O:		WORK ORDER CHANGES					
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Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Powdercoat

Powder Coating

M 118439

Memo

8:50 0F

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

9:400
9:20
10:00 0F
400
10:30

0.00

140

QC3- Inspect Part Finish

Memo

0.00

140

QC

Quality Control

1XSM 11/11/24

EJ 11/11/24 D

W/O:		WORK ORDER CHANGES						
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1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

6A
W/O
76488

BB/11/24 ①

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/128 ②

11/125 ①

W/O:		WORK ORDER CHANGES							
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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, November 15, 2011 3:59:40 PM

Work Order ID: 76495

76495

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3		Manufactured	No			100	Each	18.0000	2	2		11/11/19	**
D3328-3 Basket Hinge													
							<u>Location</u>	<u>Loc Qty</u>					
							WA005	18					
							33872	18					
D3348-1		Manufactured	No			100	Each	15.0000	4	4		11/11/19	**
D3348-1 Clevis													
							<u>Location</u>	<u>Loc Qty</u>					
							WA	14					
							75575	14					
							WA005	1					
							44246	1					
D3349-3		Manufactured	No			100	Each	4.0000	2	2		11/11/19	**
D3349-3 Spacer Bushing													
							<u>Location</u>	<u>Loc Qty</u>					
							WA	4					
							72930	4					
D3367-1		Manufactured	No			100	Each	8.0000	2	2		11/11/19	**
D3367-1 Mounting Bracket													
							<u>Location</u>	<u>Loc Qty</u>					
							WA005	8					
							43228	8					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

Page 2

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76495

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

307.3682

46.6

49.05263

**

*11/11/23****M4130NTS0 500W 035***

4130 Square tube .500 x .500 x .035w

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT034	307.3682	
109127	158.152	
109385	15.75	
112786	39.2488	
119441	57.8774	49.05263
119506	36.34	

M569EX0.50-18F

Purchased

No

100

sf

146.0000

28

28

**

*11/11/21****M569FX0 50-18F***

569 Expanded Metal

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	146	
112776	10	
117806	4	
119226	4	
119404	128	(30)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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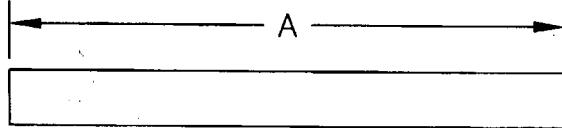
DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3324 REV. B SHEET 1 OF 3		
DATE 05.03.04			TITLE BASKET BASE ASSEMBLY	SCALE NTS
	A	04.10.20	NEW ISSUE	
	B	05.03.04	UPDATE MESH MATERIAL SPEC	

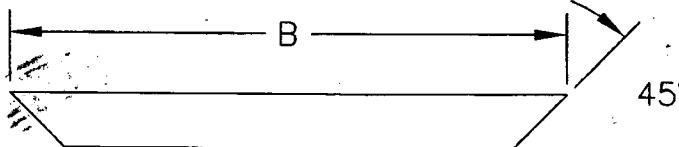
PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

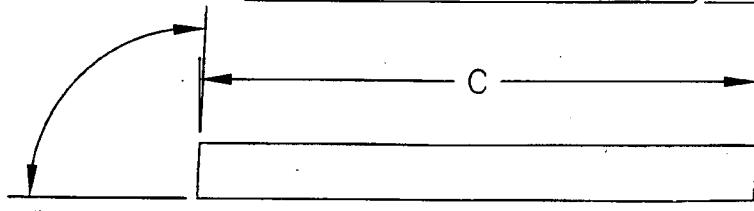
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *M495*



RELEASED
05.03.05



OKAY
45° (TYP. BOTH ENDS)



AS 08.12.15
UNDER REVIEW
J5.03.05 RH
FLASHLINED
DE MFG. 30 N PG 2

93°
(REF)

3° (TYP. BOTH ENDS)

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					*		

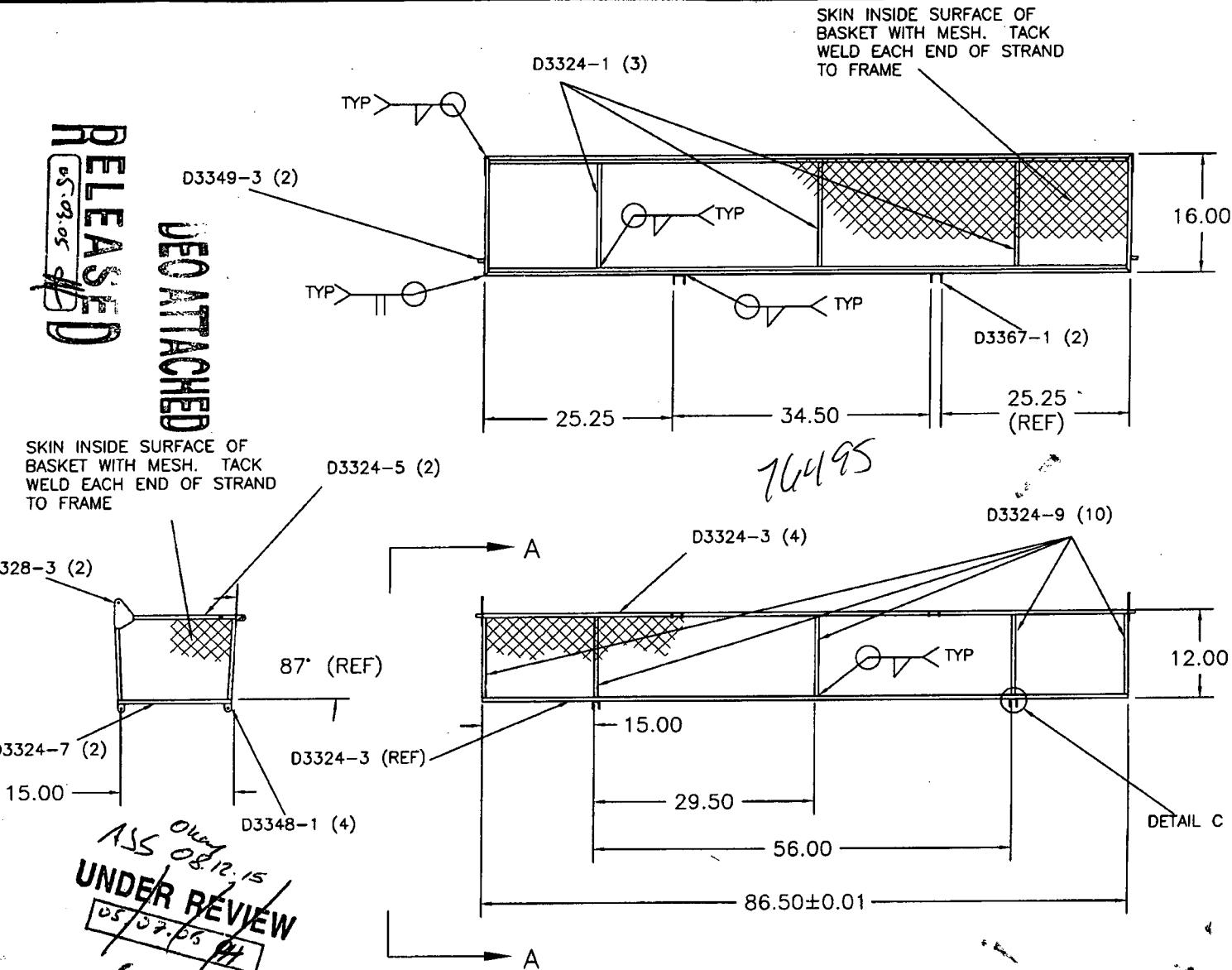
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3324
DATE 05.03.04	TITLE BASKET BASE ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:20



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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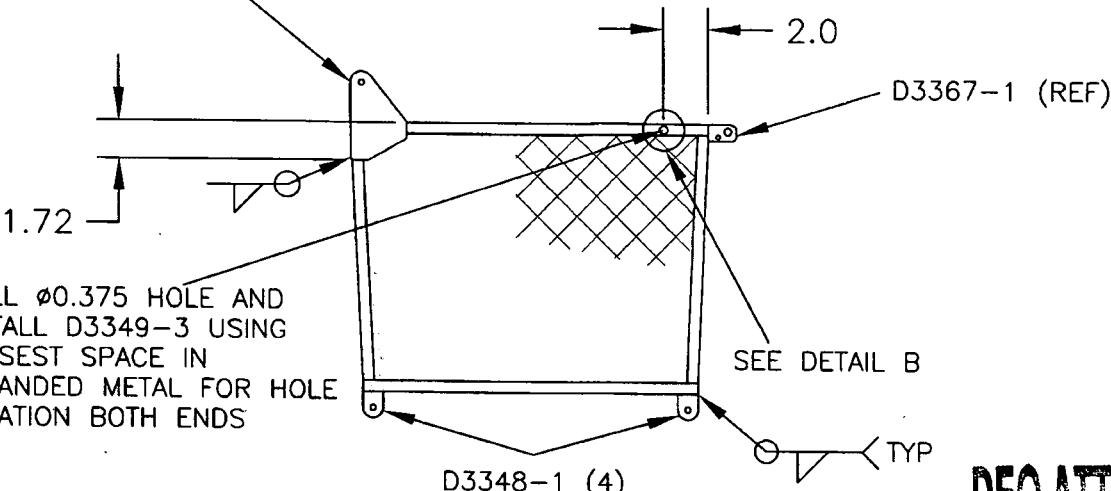
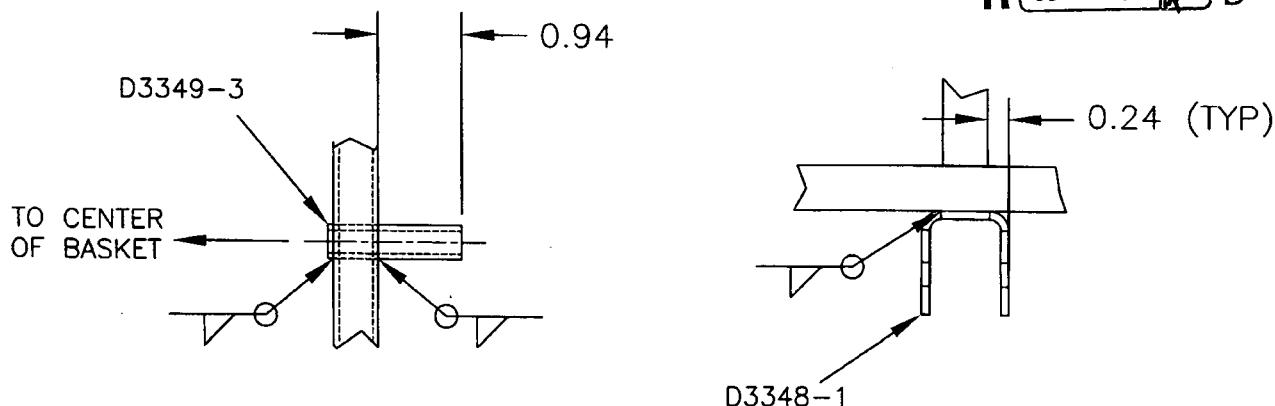
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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3324
DATE 05.03.04	TITLE	SCALE 1:8

D3328-3
HINGE PLATE
(TYP BOTH ENDS)

**DET ATTACHED****RELEASED**
05.03.05

DETAIL B
(SCALE 1:2)

Okay
ASS 08.12.15
UNDER REVIEW
05.03.05

DETAIL C
(SCALE 1:2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

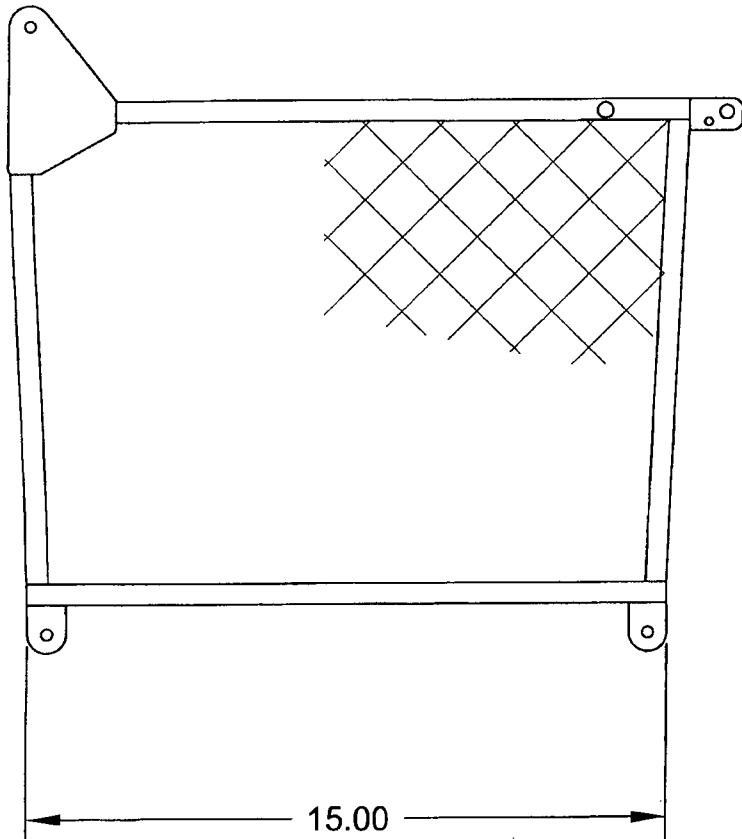
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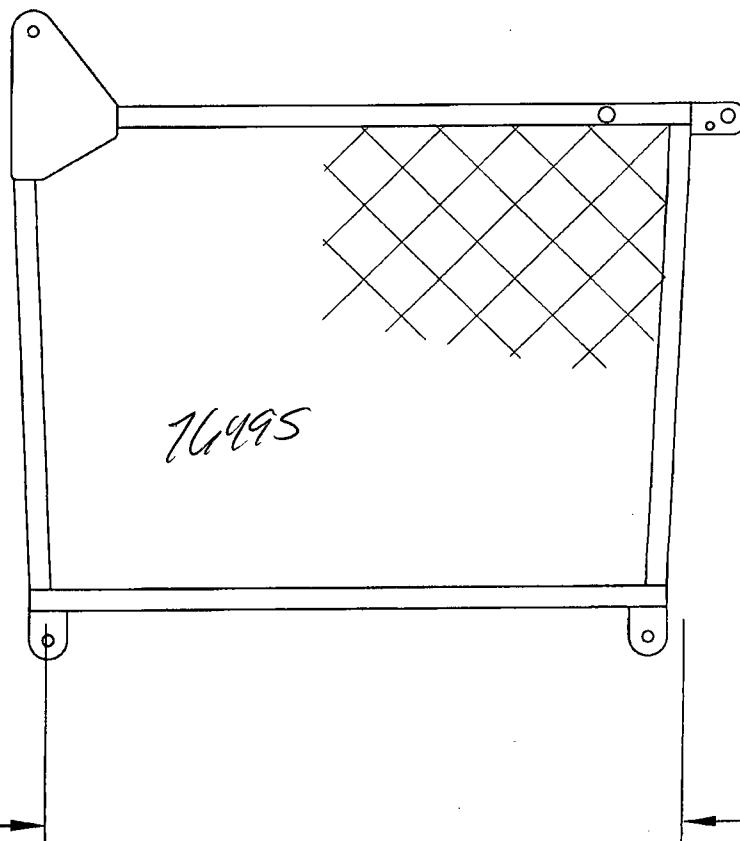
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN DATE	AJS 08.11.28	CHECKED DATE 08.11.28	MFG. APPR. DATE 08/12/01	APPROVED DATE 08/12/01	DE APPR DATE 08.12.01	

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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